

Date: Wednesday, 11/21/2007 12:47:38 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number : 35916	
Estimate Number : 10531	
P.O. Number : <i>N/A</i>	Part Number : D2572
This Issue : 11/21/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2572 REV E
Prsht Rev. : <i>NC</i>	Project Number : <i>N/A</i>
First Issue : <i>NA</i> Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 34813	Material : <i>NA</i>
Written By : <i>[Signature]</i>	Due Date : 1/15/2008 Qty: 12 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est. 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
7075-T7351 8.25X5.0X2.5
Make from D6101-005 billet for D2572
Ensure that grain is along 5.00" length
Batch No: *B31388*

[Signature] 07/12/27

(12)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. *35916* Double check by: *DSP*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
4-Deburr and remove all machining marks
5-Tumble to remove shap edges.

[Signature] SF 08/01/03

(12)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2571 & D2572

[Signature] SF 08/01/03

(12)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

[Signature] SF 08/01/03

(12)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AD Date: 08/07/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:47:38 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 35916

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 08/01/04

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M.H.

08/01/07

12X

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat **SANDTEX GREEN**
(Ref: 4.3.5.1) as per QSI 005 4.3

M102316

M.H.

08/01/09

12X

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-01-09

12X

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

AS

08/01/09

12X

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/01/11

Job Completion



u 08.01.11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	35916
Description: Saddle, Fwd Inboard		Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.001	8.000	8.000		
F	0.490	0.510		0.498	.495	.500	.500		
G	0.257	0.262	DT8683	0.260	.258	.258	.258		
H	0.375	0.380	DT8684	0.376	.377	.377	.377		
I	0.490	0.510		0.500	.500	.500	.500		
J	1.174	1.184		1.178	1.180	1.180	1.180		
K	0.558	0.578		0.567	.567	.577	.570		
L	1.174	1.184		1.178	1.180	1.180	1.180		
M	1.490	1.500		1.493	1.500	1.500	1.500		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.872	3.872	3.872	3.872		
P	0.115	0.135		0.126	.126	.128	.128		
Q	0.115	0.135		0.135	.130	.132	.132		
R	0.240	0.260		0.249	.250	.252	.252		
S	0.115	0.135		0.134	.134	.131	.131		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.233	.230	.245	.247		
W	0.115	0.135		0.122	.125	.125	.125		
X	0.307	0.312		0.311	.311	.311	.311		
Y	0.760	0.765		0.760	.760	.760	.760		
Z	0.352	0.372		0.358	.358	.358	.358		
AA	0.470	0.530		0.500	0.500	0.500	0.506		
AB	0.615	0.635		0.627	.629	.629	.629		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.241	.241	.250	.250		
AE	1.375	1.395		1.387	1.390	1.390	1.390		
AF	0.115	0.135		0.135	.135	.135	.135		
AG	0.240	0.280		0.260	.260	.260	.260		
AH	0.240	0.260		0.247	.248	.260	.259		
AI	2.000	2.020		2.001	2.001	2.000	2.000		
AJ	0.023	0.043		0.033	.033	.033	.033		
Accept/Reject									

Measured by:	RF
Date:	08/02/02 / 08/01/03

Audited by:	SA
Date:	08/01/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	35916
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5#	6#	7#	8#		
A	0.438	0.443	DT8682	.441	0.440	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	0.500	.502	.502		
G	0.257	0.262	DT8683	.260	.260	.260	.260		
H	0.375	0.380	DT8684	.376	.377	.377	.377		
I	0.490	0.510		.500	.500	.500	0.499		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.568	.568	.568	0.570		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.490	1.500		1.500	1.500	1.500	1.500		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.126	.126	.126		
Q	0.115	0.135		.125	.125	.125	0.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.125	.125	.125	0.129		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.963	2.963	2.963	2.963		
V	0.230	0.250		.240	.240	.240	0.238		
W	0.115	0.135		.125	.125	.125	.131		
X	0.307	0.312		.311	0.309	.310	.310		
Y	0.760	0.765		.765	0.760	.760	.760		
Z	0.352	0.372		.360	0.364	0.367	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.629	0.627	0.627	.627		
AC	0.053	0.073		.063	.063	.063	0.063		
AD	0.240	0.260		.250	.250	.250	0.245		
AE	1.375	1.395		1.385	1.385	1.385	1.388		
AF	0.115	0.135		.125	.125	.125	0.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.250	.250	.250	0.247		
AI	2.000	2.020		2.000	2.000	2.000	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	SA
Date:	07/12/29 / 08/01/02

Audited by:	SA
Date:	08/01/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	35916
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	90	210	211	212	By	Date
A	0.438	0.443	DT8682	.441	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.505	.505	.505	.502		
G	0.257	0.262	DT8683	.260	.260	.260	.260		
H	0.375	0.380	DT8684	.377	0.372	.377	.370		
I	0.490	0.510		0.500	0.500	.500	.500		
J	1.174	1.184		1.180	1.179	1.179	1.180		
K	0.558	0.578		0.570	.570	.570	.570		
L	1.174	1.184		1.180	1.179	1.179	1.180		
M	1.490	1.500		1.500	1.495	1.495	1.500		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.873	3.873	3.873		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		0.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.247		
S	0.115	0.135		0.131	.129	.129	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.963	2.961	2.963	2.963		
V	0.230	0.250		0.235	.237	.240	.240		
W	0.115	0.135		.135	.135	.135	.135		
X	0.307	0.312		.311	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.360	.360	.360	.360		
AA	0.470	0.530		.500	.500	.500	.506		
AB	0.615	0.635		.630	.630	.630	.620		
AC	0.053	0.073		.063	.063	0.063	.063		
AD	0.240	0.260		.246	.246	.250	.250		
AE	1.375	1.395		1.388	1.386	1.386	1.386		
AF	0.115	0.135		0.135	.135	.135	.135		
AG	0.240	0.280		.260	.255	.260	.260		
AH	0.240	0.260		0.245	.246	.246	.250		
AI	2.000	2.020		2.002	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

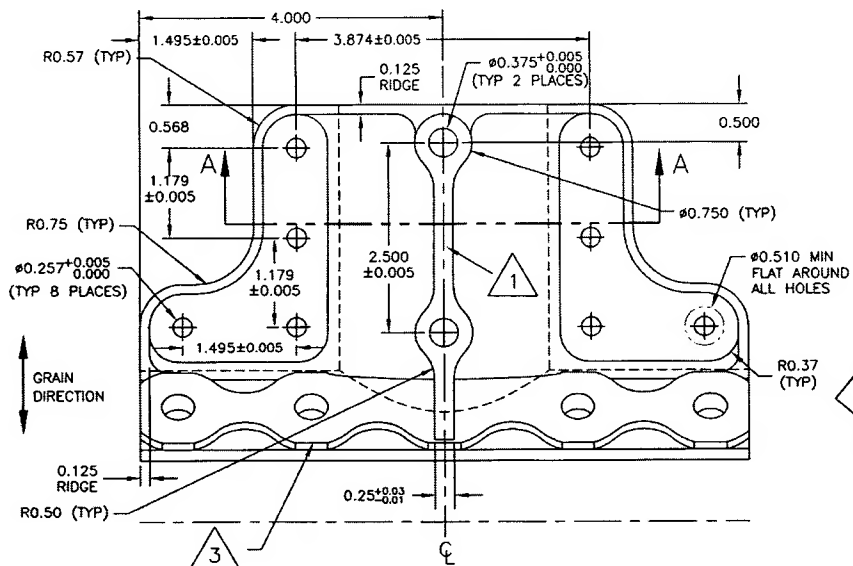
Measured by:	RF
Date:	07/12/31 / 08/01/02

Audited by:	SA
Date:	08/01/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

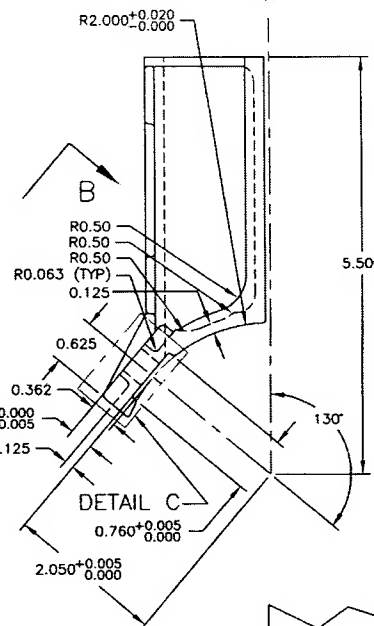
05.12.06



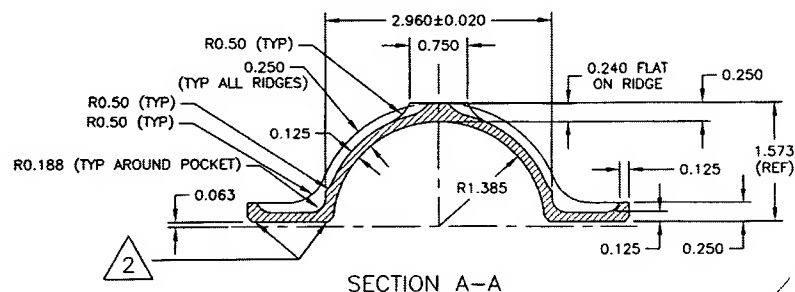
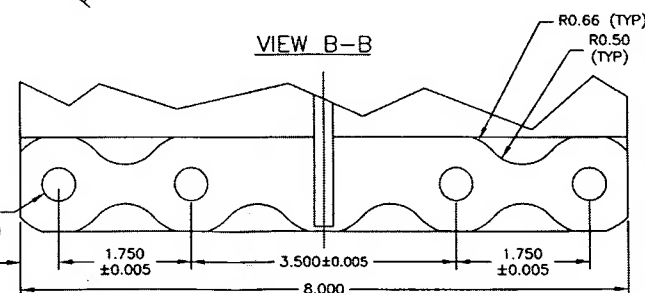
NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
3 CHAMFER 0.063 x 45° ALL AROUND
4 CHAMFER 0.033 x 45° (SEE DETAIL C) E

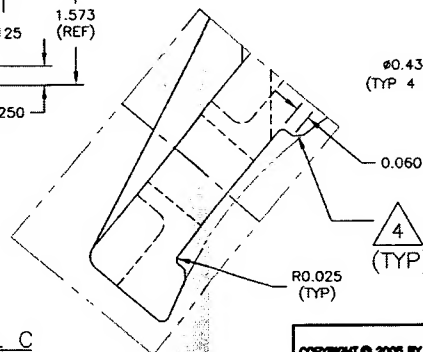


VIEW B-B



SECTION A-A

DETAIL C
SCALE 2:1



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED		APPROVED
DATE	05.07.13	TITLE
		INNER FWD SADDLE

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2:3

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